



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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RH

D119-646-043
Job Sheet 199226



Part No: D119-646-043

Job Qty: 1 pcs

Part Name: AW119 Replacement Skidtube with Wearpads, Float Compatible - Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/15/19

Job Tracking No:

Due Date: 9/6/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IIN-D119-646 REV.D, D3905-041 REV.F IPP RevA: New issue DD verified by:EC IPP revB 10.02.22 per PAR 09-043 EC verified by:DD IPP REVC 12.11.05 (DEOD3905-B-1)(ecn 12-675) DD verf:JLM IPP REV:D 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:E 15.01.19 AS PER ECN-14-628 DD verf:JLM IPP REV:F 16.11.02 chg as per D3905 revD(DEO) DD verf:JLM IPP REV:G 17.05.23 as per dwg D3905 rev.e DD verf:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Workcenter / Supplier Lead Time	Sign-off
110	Skidtubes - 1	1 pcs	9/6/19	0.00	3.68	Skidtubes - 1		TF	
						Skidtubes - 2			
						Skidtubes - 3			
						Skidtubes - 4			
						Skidtubes - 5			
						Skidtubes - 6			
						Skidtubes - 7			
120	Handfinish - 1-1 Chemical- B4B	1 pcs	9/6/19	0.00	1.56	Handfinish - 1 - 1 - B4B		BER 19-08-22	
						Handfinish - 1 - 2 - B4B			
						Handfinish - 1 - 3 - B4B			
						Handfinish - 1 - 4 - B4B			
						Handfinish - 1 - 5 - B4B			
						Handfinish - 1 - 6 - B4B			
						Handfinish - 1 - 7 - B4B			
						Handfinish - 1 - 8 - B4B			
						Handfinish - 1 - 9 - B4B			
						Handfinish - 1 - 10 - B4B			
						Handfinish - 1 - 11 - B4B			
						Handfinish - 1 - 12 - B4B			
						Handfinish - 1 - 13 - B4B			
						Handfinish - 1 - 14 - B4B			
						Handfinish - 1 - 15 - B4B			
						Handfinish - 1 - 16 -			



Container No: S207658



Part: D119-646-043

Job No: 199226

Serial No/Batch: S207658

Revision: D,F

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 19/06/17, TC STC LoA P.

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Container No: S207658



Part: D119 - 646 - 043

Job No: 199226

Serial No/Batch: S207658

Revision: D,F

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 18/04/17, TCA STC LoA P.

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					B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
130 QC 7	1 pcs	9/6/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	MBQ
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
140 QC 5	1 pcs	9/6/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	

170 Skidtubes - 2 - B4B	1 pcs	9/6/19	0.00 3.68	QC 5 - 61	
				QC 5 - 81	
				Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MGL TF
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
180 QC 5	1 pcs	9/6/19	0.00 0.00	Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Skidtubes - 3 - B4B	1 pcs	9/6/19	0.00 3.68	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF BE
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
200 QC 5	1 pcs	9/6/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	DAS 24 9-89
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
210 QC 10	1 pcs	9/6/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	DAS 24 9-89
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	

					QC 10 - 58	
					QC 10 - 9	
220	Handfinish - 2-1 Pressure- B4B	1 pcs	9/6/19	0.00 1.56	Handfinish - 2 - 1 - B4B	BEB 19-09-22
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
230	Spray Paint - 2 - B4B	1 pcs	9/6/19	0.00 0.42	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	120 19-9-29
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
235	Outsource	1 pcs	9/6/19		ATE003-VC	
240	QC 14	1 pcs	9/6/19	0.00 0.00	QC 14 - 15	M 19-10-01
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
250	Handfinish - 4-1-Assembly-B4B	1 pcs	9/6/19	0.00 1.56	Handfinish - 4 - 1 - B4B	M 19-10-02
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
260	QC 5	1 pcs	9/6/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	

					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	OCT 02 2019 40 DAS
					QC 5 - 61	9-89
					QC 5 - 81	
270 Handfinish - 4-2-Assembly-B4B	1 pcs	9/6/19	0.00 1.56	Handfinish - 4 - 1 - B4B		UL 19-10-01
				Handfinish - 4 - 10 - B4B		
				Handfinish - 4 - 11 - B4B		
				Handfinish - 4 - 12 - B4B		
				Handfinish - 4 - 13 - B4B		
				Handfinish - 4 - 14 - B4B		
				Handfinish - 4 - 15 - B4B		
				Handfinish - 4 - 2 - B4B		
				Handfinish - 4 - 3 - B4B		
				Handfinish - 4 - 4 - B4B		
				Handfinish - 4 - 5 - B4B		
				Handfinish - 4 - 6 - B4B		
				Handfinish - 4 - 7 - B4B		
				Handfinish - 4 - 8 - B4B		
				Handfinish - 4 - 9 - B4B		
280 QC 5	1 pcs	9/6/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40	OCT 02 2019 40 DAS	
				QC 5 - 61	9-89	
				QC 5 - 81		
285 Handfinish - 3-1- WingWalk-B4B	1 pcs	9/6/19	0.00 1.56	Handfinish - 3 - 1 - B4B		UL 19-10-01
				Handfinish - 3 - 2 - B4B		
				Handfinish - 3 - 3 - B4B		
				Handfinish - 3 - 4 - B4B		
				Handfinish - 3 - 5 - B4B		
286 QC 5	1 pcs	9/6/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		

					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS OCT 04 2019 40 9-89
					QC 5 - 61	
					QC 5 - 81	
295	Packaging 3-1 - Stock - B4B	1	9/6/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	DAS 78 9-89
					Packaging 3 - 26 - B4B	OCT 23 2019
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS 21 9-89
297	DC - 1 - B4B	1	9/6/19	0.00 0.00	DC - 1 - B4B	OCT 23 2019
	pcs				DC - 2 - B4B	
300	QC 21 - FG	1	9/6/19	0.00 0.00	QC 21 - FG - 21	DAS 21 9-89
	pcs				QC 21 - FG - 70	OCT 23 2019
					QC 21 - SA - 53	
Part Op 110 - (Skid tubes) 1- Bend FWD end of tube using Bender 1 and bend prog D3905 FWD per dwg D3905 (FOLIO -04) 2- Descriptions: Cut FWD end of tube as per dwg D3905. 3- Cut AFT end of tube as per dwg D3905. 4- Buff out marks left from bending 5 -Install drill Jig DT9480 drill X-bolt spacer pilot holes using 3/16" drill first side only. 6- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 7- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes usin DT9480 8- Drill FWD cap holes using DT8215. 120 - (Chemical Conversion Coat per QSI005 4.1) 130 - (QC7-Inspect Chemical Conversion Coat) 140 - (QC5- Inspect part completeness to step on W/O)						

- 170 - (Skidtubes) Open FWD Saddle holes to finish size as per dwg and deburr 1-Bond web in place as per Dwg D3905 & QSI 015. (at 42.95" ref.) A/R Sikaflex-291 5200625 Sikaflex expire date: 20-07-25 Start: _____ Time: _____ Finish: _____ Time: _____ ***** (Adhere for 12 hours) ***** 2--Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Install drop pins in crossbolt spacer holes to maintain web position. 3- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 4- Drill Tow ring hole using DT10047. Open to finished size. 5- Open FWD & AFT cap holes per dwg. Countersink Fwd cap only as per detail "C" 6-Open crossbolt spacer holes to finished size. Drill most Fwd wearplate holes using DT9816 (15.21") 7-Deburr crossbolt spacer holes as per Dwg D3905 and blow out chips from inside the tube 8- Drill holes for wearpads using DT9613 & D
- 180 - (QC5- Inspect part completeness to step on W/O)
- 190 - (Skidtubes) NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE,IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3905. Remember to back drill each hole before welding the other side. Use aluminum rod A/R Aluminum Rod 139011 2-Grind cross bolt welds flush as per Dwg D3905. Ensure no pin hole. 3-Counterbore 5/16" x 0.750" deep as per Dwg D3905. 4- Deburr & Scribe batch # on Aft end of tube. 5- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skidtube batch#.
- 200 - (QC5- Inspect part completeness to step on W/O) TEST FIT USING FIXTURE DT10091.
- 210 - (QC10- Inspect visual per QSI004- ground welds)
- 220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
- 230 - (Spray Paint / NDT Room) *****AS PER DETAIL"F" NOTE 8, SHEET 8 MASK THIS AREA, DO NOT APPLY PRIMER OR PAINT***** PRIME AS PER DWG AND QSI 005 4.2 BATCH: 5200299 PAINT WHITE AS PER DWG AND QSI 005 4.2 BATCH: 5215105
- 240 - QC14- Inspect Spray Paint)
- 250 - (Assemble as per dwg) 1-Install inserts as per Dwg D3905.
- 260 - (QC5- Inspect part completeness to step on W/O)
- 270 - (Assemble as per dwg) 1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 5200625 Sikaflex expire date: 20-7-2 2-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 41138843 3 -Inspect for foreign objects as per QSI 024 4 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 5200625 Sikaflex expire date: 20-7-2 5 -Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 5200625 Sikaflex expire date: 20-7-2 6- Install (2)D5101-041 and (1)D5101-047 as per dwg by using DT10117
- 280 - (QC5- Inspect part completeness to step on W/O)
- 285 - HandFinish3 (Wing Walk as per dwg QSI005 4.4 Batch 209032)
- 286 - (QC5- Inspect part completeness to step on W/O)
- 295 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D119-646-Location: _____ PPP Rev: _____
- 297 - (Document Control) Photocopy bluefile & type labels per PPP D119-646-043 CHG 006
- 300 - (QC21- Final Inspection - Work Order Release)

Job COM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n - I' Beam Tube 4"	1 pcs (1 ea)	110-Skidtubes - 1	5168371
D3885-3	Float Web	1 pcs (1 ea)	170-Skidtubes - 2 - B4B	5096476
D2579	Crossbolt Spacer	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	5097840
D2855-5	Cap	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5002078
D3681-1	Spacer	12 pcs (12 ea)	190-Skidtubes - 3 - B4B	5211630
D3903-1	Spacer	12 pcs (12 ea)	190-Skidtubes - 3 - B4B	5211415
ALS4-1032-130	Rivnut	42 Ea (42 ea)	250-Handfinish - 4-1-Assembly-B4B	5057257
D3683-3	Insert	12 pcs (12 ea)	250-Handfinish - 4-1-Assembly-B4B	N/A
ALS4-1032-225	Rivnut	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5192155
AN3C4A	Bolt	6 Ea (6 ea)	270-Handfinish - 4-2-Assembly-B4B	5217813
AN3C5A	Bolt	38 Ea (38 ea)	270-Handfinish - 4-2-Assembly-B4B	5216219
AN4C46A	Bolt	3 Ea (3 ea)	270-Handfinish - 4-2-Assembly-B4B	5206468
D2855-3	Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5126407
D3492-5	Plug	24 pcs (24 ea)	270-Handfinish - 4-2-Assembly-B4B	5197670
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	F164002
D3847-1	Wearpad	8 pcs (8 ea)	270-Handfinish - 4-2-Assembly-B4B	5211574
D3847-11	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5136646
D5101-041	Crossbolt Spacer Assembly	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	5210627
D5101-047	Crossbolt Spacer Assembly	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5142528
D5101-3	Insert	6 pcs (6 ea)	270-Handfinish - 4-2-Assembly-B4B	5208515
D5101-5	Insert	6 pcs (6 ea)	270-Handfinish - 4-2-Assembly-B4B	5194906
MS21043-4	Nut	3 Ea (3 ea)	270-Handfinish - 4-2-Assembly-B4B	5198136
MS24694-C52	Screw	2 Ea (2 ea)	270-Handfinish - 4-2-Assembly-B4B	5067269
MS27039C4-08	Screw	12 Ea (12 ea)	270-Handfinish - 4-2-Assembly-B4B	
NAS1149C0332R	Washer (AN960C10L)	44 Ea (44 ea)	270-Handfinish - 4-2-Assembly-B4B	5193136
NAS1611-005	O-Ring	24 Ea (24 ea)	270-Handfinish - 4-2-Assembly-B4B	5194427
NAS1149C0416R	Washer	6 Ea (6 ea)	270-Handfinish - 4-2-Assembly-B4B	5092017

Job Allocations

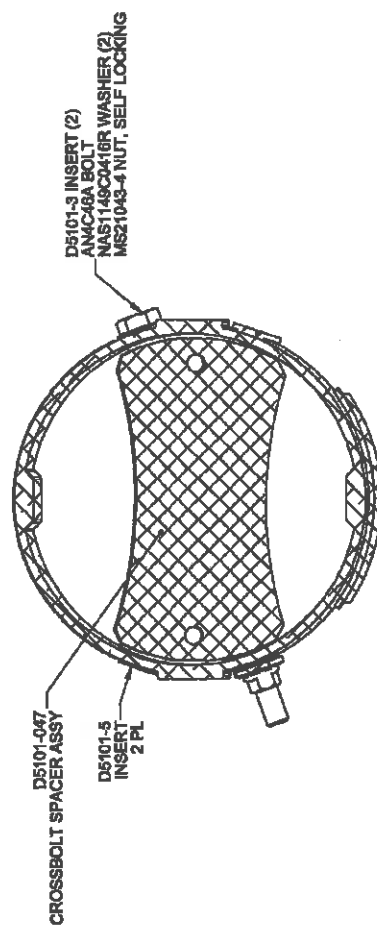
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2500-1-190	1	65	0
170-Skidtubes - 2 - B4B	D3885-3	1	15	0
190-Skidtubes - 3 - B4B	D2579	2	87	0
	D2855-5	1	41	0
	D3681-1	12	84	0
	D3903-1	12	79	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	42	6,812	0
	D3683-3	12	218	0
270-Handfinish - 4-2-Assembly-B4B	ALS4-1032-225	1	1,130	0
	AN3C4A	6	1,080	0
	AN3C5A	38	862	0
	AN4C46A	3	66	0
	D2855-3	1	78	0
	D3492-5	24	292	0
	D3672-1	2	1,493	0
	D3847-1	8	21	0
	D3847-11	1	8	0
	D5101-041	2	2	0
	D5101-047	1	6	0
	D5101-3	6	24	0
	D5101-5	6	36	0
	MS21043-4	3	839	0
	MS24694-C52	2	60	0
	MS27039C4-08	12	212	0
	NAS1149C0332R	44	2,917	0
	NAS1149C0416R	6	100	0
	NAS1611-005	24	454	0

Part Specifications

Specifications could not be found.

1 2 3 4 5 6 7 8

D C B A

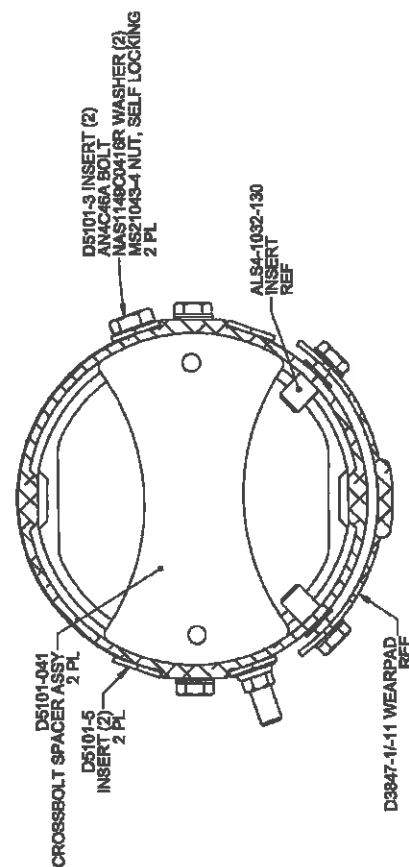


D5101-3 INSERT (2)
AN4C46A BOLT
NAS1148C0416R WASHER (2)
MS21043-4 NUT, SELF LOCKING

D5101-047
CROSSBOLT SPACER ASSY

D5101-5
INSERT
2 PL

SECTION B-B
SCALE 12X



D5101-3 INSERT (2)
AN4C46A BOLT
NAS1148C0416R WASHER (2)
MS21043-4 NUT, SELF LOCKING
2 PL

ALS4-1032-130
INSERT
REF

D5101-041
CROSSBOLT SPACER ASSY
2 PL

D5101-5
INSERT (2)
2 PL

D3847-4/-11 WEARPAD
REF

SECTION A-A
SCALE 12X

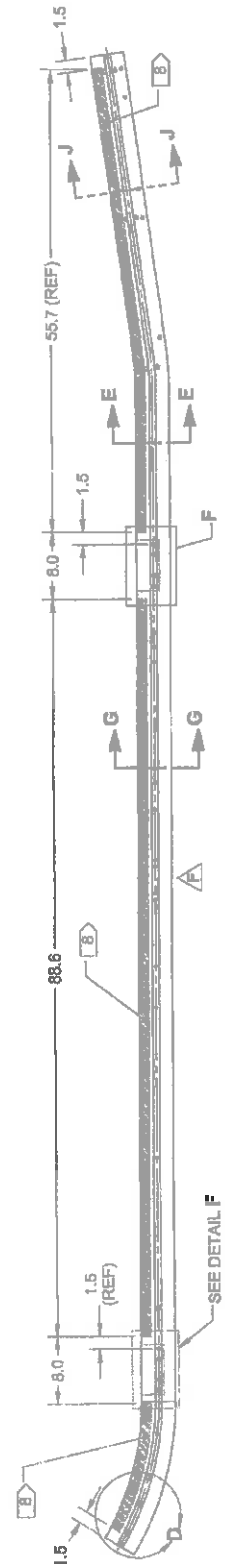
DESIGN	AJS	DART AEROSPACE USA, INC.	REV. F
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	D3905
MFG. APPR.	DO	TITLE	A1119 FLOAT SKIDTUBE ASSY
APPROVED	NO	SCALE	SHEET 5 OF 14
DE APPR.	DS	NTS	
DATE	18.08.16		

CONTINUED FROM SHEET 4 OF 14
DRAWN BY: J. F. EUGENE, OR
CHECKED BY: M. W. DOUGLAS, OR
MFG. APPR. BY: D. O. DOUGLAS, OR
APPROVED BY: N. O. DOUGLAS, OR
DE APPR. BY: D. S. DOUGLAS, OR
DATE: 18.08.16

RELEASED
JAN 19 1991

1 2 3 4 5 6 7 8

ITEM	QTY	P/N	DESCRIPTION
	X	D3905-053	SKIDTUBE SUB ASSY
1	2	D2679	CROSS BOLT SPACER
2	12	D3881-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-063	SKIDTUBE SUB ASSEMBLY
5	10	ALS4-1032-130	INSERT



D3905-053 SKIDTUBE SUB ASSEMBLY

RELEASED
94

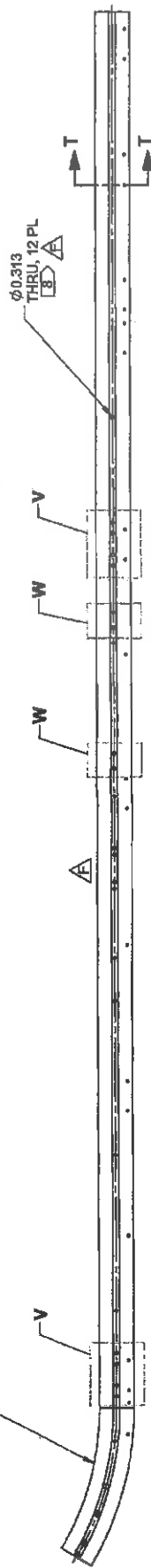
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-6044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

DESIGN	ALIS	DART AEROSPACE USA, INC.
DRAWN	ZF	EUGENE OR
CHECKED	MW	DRAWING NO. D3905
MFG. APPR.	DD	REV. F
APPROVED	NO	SHEET 7 OF 14
DE APPR.	DS	TITLE A119 FLOAT SKIDTUBE ASSY
DATE	18.08.16	SCALE NTS

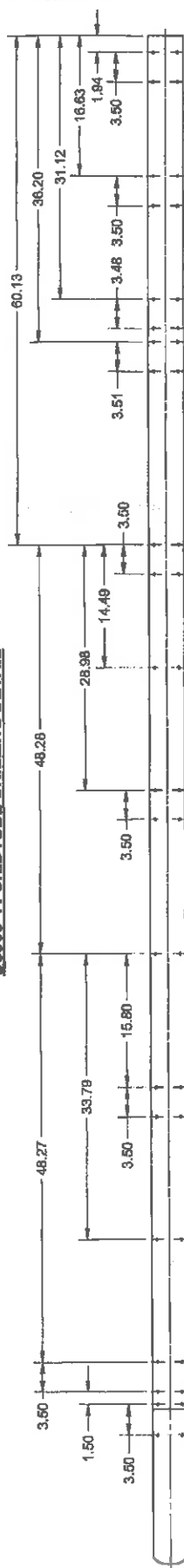
COMPONENT IS OWNED BY DART AEROSPACE USA, INC.
ALL RIGHTS RESERVED. NO PARTS MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.

1 2 3 4 5 6 7 8

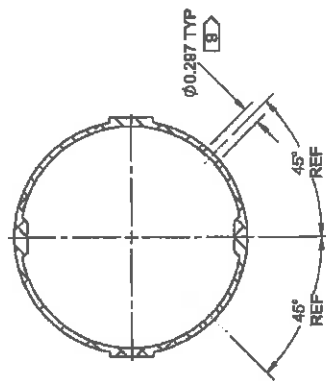
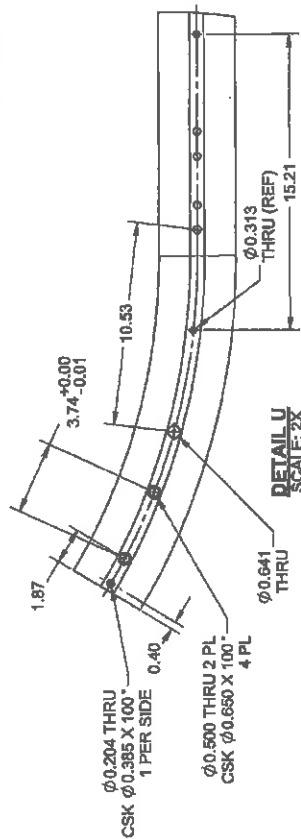
SEE DETAIL U



D3905-11 SKIDTUBE DRILLING DETAIL



WEARPAD/WEARPLATE HOLE PATTERN
FOR REFERENCE ONLY
DRILL USING DT8613/DT8645 TEMPLATE



SECTION T-T
SCALE: 2X
21 PL

- NOTES:
- 1) MATERIAL: MAKE -11 DRILL DETAIL FROM -11 FWD BEND DETAIL
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) PICK UP ON PILOT HOLES
 - 9) USE DART DRILL TEMPLATE DT8613/DT8645 TO LOCATE AND DRILL Ø0.287 HOLES FOR WEARPAD/WEARPLATE INSERTS.

DART AEROSPACE USA, INC.

EUGENE, OR

DRAWING NO.

D3905

REV. F

SHEET 11 OF 14

SCALE

NTS

A119 FLOAT SKIDTUBE ASSY

COMPONENT 9 2004 BY TART AEROSPACE USA, INC.

WEARPAD/WEARPLATE HOLE PATTERN, AND THE PATTERN FOR THE WEARPAD/WEARPLATE INSERTS.

SEE DETAIL U FOR THE WEARPAD/WEARPLATE HOLE PATTERN.

APPROVED

DESIGN

DRAWN

CHECKED

MFG. APPR.

APPROVED

DE APPR.

DATE

18.08.16

NO.

D8

DD

MM

ALB

ZF

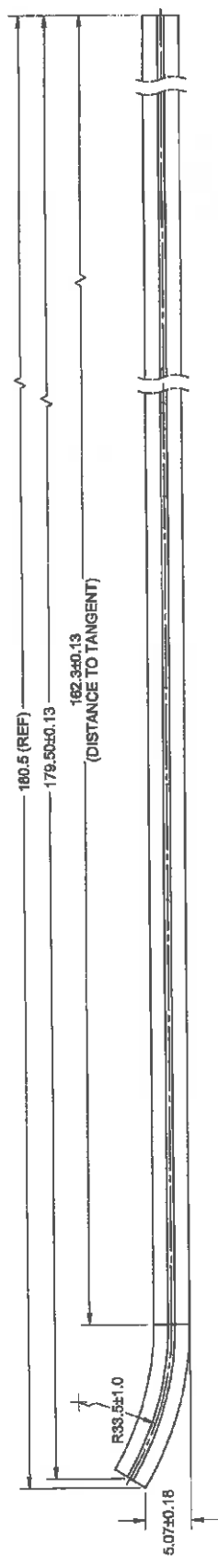
21

21

21

21

1 2 3 4 5 6 7 8



D3905-1 SKIDTUBE FWD BEND DETAIL

- NOTES:
- 1) MATERIAL: MAKE -1 FWD BEND DETAIL FROM -3 PILOT HOLE DETAIL
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) DAMAGE TOLERANCE ON FWD BEND: THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.160" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

OCT 19 94

DESIGN	AJS	DART AEROSPACE USA, INC.	REV. F
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO. D3905	
MFG. APPR.	DD	TITLE	SHEET 13 OF 14
APPROVED	NO	A119 FLOAT SKIDTUBE ASSY	SCALE
DE APPR.	DS		NTS
DATE	18.08.16		

COMPANY: DART AEROSPACE USA, INC.
10000 W. 10TH AVE. SUITE 100
DENVER, CO 80202
TEL: 303.751.1000 FAX: 303.751.1001
WWW.DARTAEROSPACE.COM

1 2 3 4 5 6 7 8

NCR No.

Route update only

Job: _____		DISPOSITION						DEPARTMENT/PROCESS									
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐						Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐									
Date :	Sequence #:		QTY Affected :							MRB (QS042)							
Description Work Order Deviation									Disposition								
									Completed By								
									Lead hand / Supervisor								
									QC / QA Coordinator								

Root Cause		FAULT CATEGORY											
☐ Operator	☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong									
☐ Manufacturing Process	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance									
☐ Equip/Tooling	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing									
☐ Handling/Preservation	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish									
☐ Material	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing									
☐ Product Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread									
☐ Process Improvement	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up										
☐ Human Factors	Other/Details:												